

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015471**Date Inspected:** 07-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Jobsite**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS OBG**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance Inspector (QAI) Bert Madison attended an American Bridge/Fluor Enterprises (AB/F) Safety Orientation and Confined Space Training for half of the shift and afterwards was present at Yerba Buena Island in California for observations relative to the work being performed by AB/F personnel at the locations noted below.

- 1). OBG Field Splice 1W/2W Weld ID: D1 Face B
- 2). OBG Field Splice 2W/3W Weld ID: D1 & D2, Face B
- 3). OBG Field Splice 5W/6W Weld ID: A1 – A5
- 4). OBG Field Splice 4E/5E Weld ID: E2, Face A

- 1). OBG Field Splice 1W/2W Weld D1 Face B

The QAI periodically observed the in process welding of OBG Field Splice 1W/2W weld ID: D1, Face B per the Flux Cored Welding (FCAW-G) process in the 4G (overhead) position by ABF welding personnel Rory Hogan (ID 3186). QC Inspector Tony Sherwood was present to monitor the progress and verify that the welding parameters were within the limits established by the approved welding Procedure Specification (WPS) identified as ABF-WPS-D1.5-3040A-4. The QAI observed that the welding parameters obtained by Mr. Sherwood appeared to be in general compliance with the contract documents and were as follows: 238 amps, 24.5 volts and a travel speed measured as 197mm per minute. Welding was in process for the remainder of this shift.

- 2). OBG Field Splice 2W/3W Weld ID: D1 & D2, Face B

The QAI periodically observed AB/F personnel performing plasma cutting to remove the backing bar and grinding to prepare the outside groove for back welding. The work at this location was not completed during this shift.

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## WELDING INSPECTION REPORT

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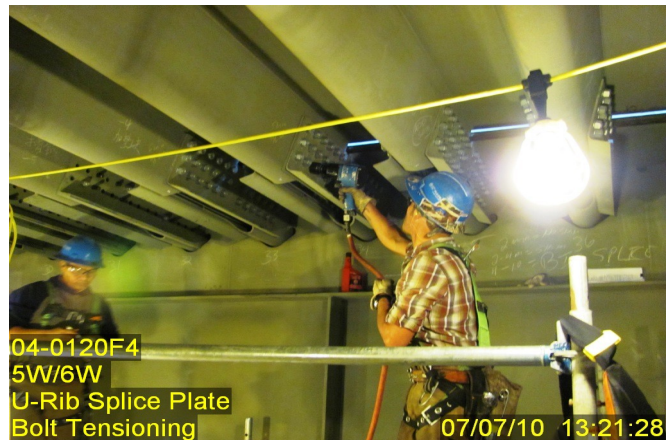
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### 3). OBG Field Splice 5W/6W Weld ID: A1 – A5

The QAI periodically observed AB/F approved welder Rick Clayborn (2773) installing fit-up gear on the OBG Field Splice 5W/6W, Weld ID: A1 – A5, Face B. The welding was per the SMAW process. QC Inspector Bonafacio Daquinag was present to monitor the progress and verify that the welding parameters were within the limits established by the approved welding Procedure Specification (WPS) identified as ABF-WPS-D1.5-F1200-A. The QAI also periodically observed QC Inspector Bonafacio Daquinag measuring the gap between the backing bar and face B of the deck plate to identify areas that require adjustment. Fit-up activities were in process during the remainder of the shift. The QAI also periodically observed AB/F personnel tensioning the bolting attaching the splice plates to the U-Rib stiffeners. See photo below.

### 4). OBG Field Splice 4E/5E Weld ID: E2, Face A

The QAI periodically observed the in process welding of OBG Field Splice 4E/5E Weld ID: E2, Face A per the Shielded Metal Arc Welding (SMAW) process in the 3G (vertical) position by Approved AB/F welder Song Tao Huang (ID 3794). See photo below. QC Inspector Bernard Docena was present to monitor the progress and verify that the welding parameters were within the limits established by the approved welding Procedure Specification (WPS) identified as ABF-WPS-D1.5-1040B. The QAI observed that the welding parameters obtained by Mr. Docena appeared to be in general compliance with the contract documents Welding Amperes =128A. Welding was in process for the remainder of this shift.



### Summary of Conversations:

None of relevance.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mohammed Fatemi (916) 813 3677, who represents the Office of Structural Materials for your project.

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**Inspected By:** Madison,Bert

Quality Assurance Inspector

**Reviewed By:** Levell,Bill

QA Reviewer

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